

Date: Friday, 01/08/2008 3:31:46 PM
 User: Julie Lecocq

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : END FITTING ASS'Y LH
 Job Number : 40958
 Estimate Number : 13344
 P.O. Number :
 This Issue : 01/08/2008 S.O. No. :
 Prsht Rev. : NC Part Number : D3763043
 First Issue : // Type : LARGE FAB ASSY Drawing Number : D3763 REVB
 Previous Run : 40685 Project Number : N/A
 Material :
 Due Date : 21/08/2008 Qty: 4 Um: Each
 Written By :
 Checked & Approved By : JUD 08.8.05
 Comment : Est Rev:A 08-05-20 new issue DD verified by:ec
 Est Rev:B 08-07-18 revB as per dwg DD verified by:EC

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1
 Pick Packing Kit

2.0 D37631 End Fitting



Comment: Qty.: 2.0000 Each(s)/Unit Total : 8.0000 Each(s)
 End Fitting
 batch: B40994 ✓ SP 08.08.20 (EX)

3.0 D37635 Tube



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)
 Tube
 batch: B40993 ✓ SP 08.08.20 (4X)

4.0 LARGE FAB 1 LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1
 1-make a 0.063" chamfer on D3763-1 fitting before ass'y SP 08.08.20
 2-assemble and tack weld as per dwg D3763 using locating pin DT9014 SP 08.08.20
 *****look at dwg before assembling parts (LH)*****
 *****remove pin before welding*****
 3-weld as per dwg D3763 QSI004
 Alum. rod Batch: H108037 SP 08.08.20 (4X)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Drawing Name: END FITTING ASSY LH

Job Number: 40958

Part Number: D3763043

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

PD 08-08-21

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

8 08/08/08 (x4)

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify with Dart part # using a fine point permanent marker and Stock

Location: 51

mf 08-08-21

8.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/08/21

Job Completion



mf 08-08-21

5.1 Alodine as per dwg. MF 08-08-21 (x4)
5.2 QL3 => JL 08-08-21 (x4)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

8

7

6

5

4

3

2

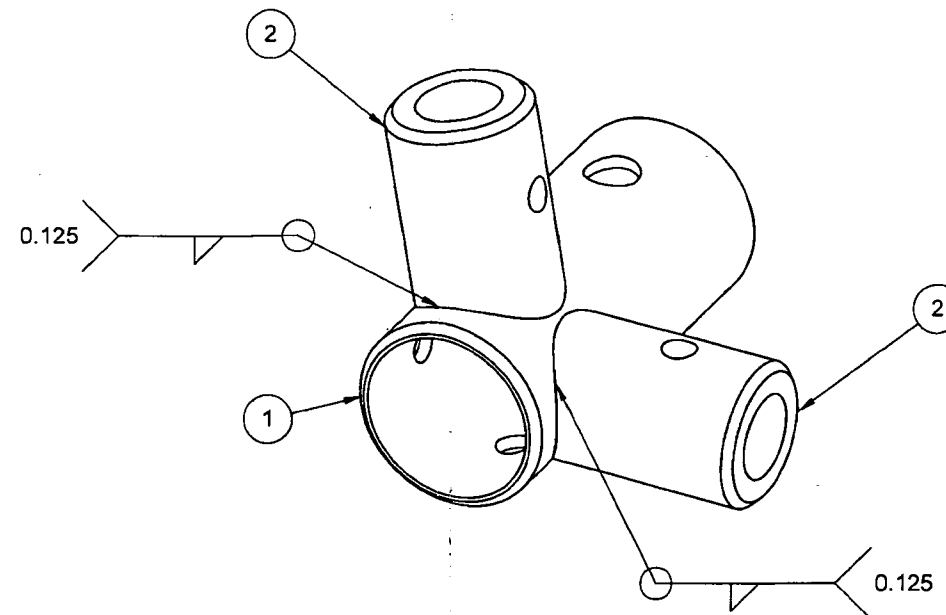
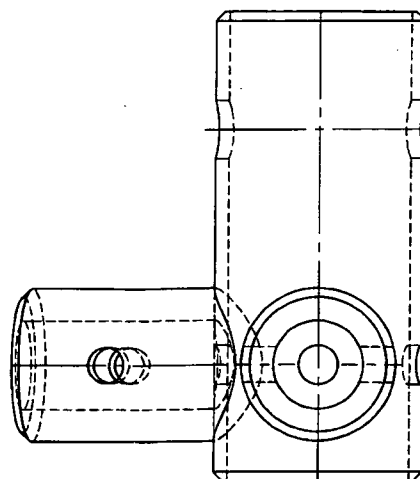
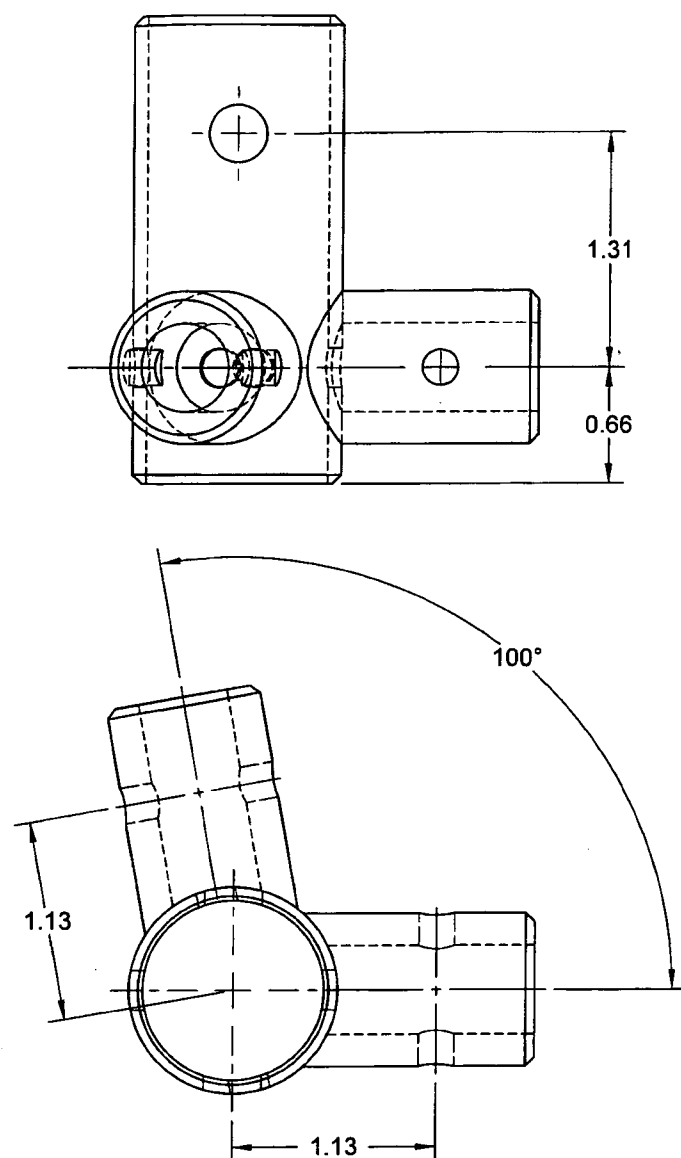
1

D

C

B

A



ITEM NO.	PART NUMBER	DESCRIPTION	QTY. (-043)
1	D3763-5	TUBE	1
2	D3763-1	FITTING	2

D3763-043 END FITTING ASSY, LH

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: CHEMICAL CONVERSION COAT ASSEMBLY PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.05 lbs
- 8) WELD: PER DART QSI 004

SHOP COPY

RETURN TO

ENGINEERING

UNCONTROLLED COPY


SUBJECT TO AMENDMENT

WITHOUT NOTICE

WORK ORDER

NO. 40902

RELEASED
08.01.10/11

DESIGN	HS	DART AEROSPACE LTD	
DRAWN	HS	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV.
MFG. APPR.		D3763	SHEET 2 OF
APPROVED		TITLE	SCALE
DE APPR.		END FITTING	NT
DATE	08.06.23	COPYRIGHT © 2008 BY DART AEROSPACE LTD	
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